

# Work Order ID 72654

Thursday, August 04, 2011 7:45:22 AM

Page 1

Item ID: D3999-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 8/4/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3999

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

6061 .040

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB11-8-11

(36)

RB11-8-11

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

Subtotal

counted  
32



QC

Memo

Quality Control

130

Bend as per dwg

0.00

SB 11/08/24

32



Brake NC

Memo

Brake NC

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

Hand Finishing

32X DM 11/08/25

**Work Order ID 72654**

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Accept



Setup Start



Revision ID:

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Item Name: Angle

Start Date: 8/4/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/16/25

counts  
(X32)

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location: ST 104

0.00

Memo

0.00

SP

(3x) SP 11-0825

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/8/25

C&amp;U/08/25

# Picklist Print

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Page 1

Work Order ID: 72654



Parent Item: D3999-5



Parent Item Name: Angle



Start Date: 8/4/2011

Required Date: 8/5/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP rev A 09.12.16 new issue Prelim EC verified by:DD IPP rev B  
10.05.10 ecn 10-562 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 		Purchased	No			100	sf	97.3000	0.048	1.010526	1.5		
6061-T6 .040 Sheet											181-8-11		

Location

Loc Qty

Loc Code

MAT021

97.3

113004

8.5

117653

88.8

117653



30

72654

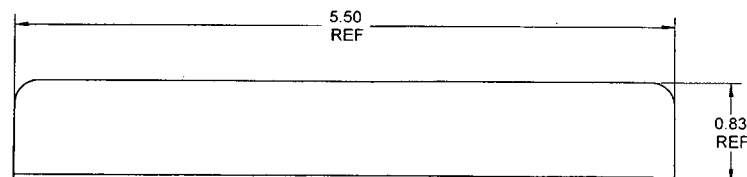
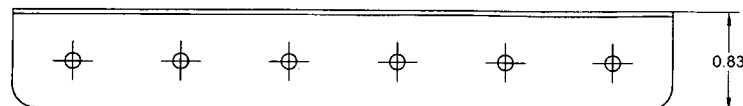
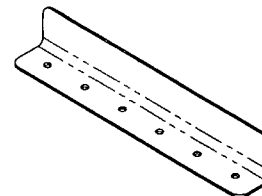
## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: B	Audited by: S	Preliminary Approval: N/A
Date: 11-8-11	Date: 11/08/11	Date: N/A

Rev	Date	Change	Revised by	Approved
A	10.08.03	New Issue	KJ 	

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3999-5	REF JCA-M47-1-02 REF JCA-M47-1-03



**D3999-5 ANGLE**

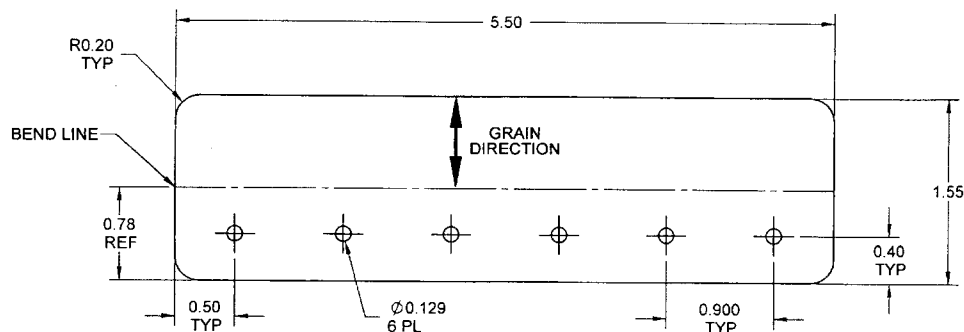
*W/072654*

**RELEASED**  
2010-05-05  
*MD*

**NOTES:**

- 1) MATERIAL: MADE FROM D3999-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3999	SHEET 6 OF 12
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BAFFLE	NTS
DATE	10.02.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D3999-5F FLAT PATTERN**

72654

**RELEASED**  
2010-05-05  
JWP

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3999	SHEET 7 OF 12
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